

Work Order ID 113268

February-12-14 10:42:27 AM

113268

Page 1

Item ID: 646.9710

Revision ID:

Item Name: Body

Start Date: 2/12/14

Required Date: 2/12/14

Reference:

646.9710
B113268

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: ML5

Date: 14-02-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.9700

C

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 7.425"

0.00

0.00

14/03/20

5 0

DAS

14

9-89

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB130

DWG REV: C

FOLIO REV: AA

2- deburr and break all sharp edges

0.00

0.00

14/04/03

5 0

DAS

14

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--|--|---|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
|--|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | |
| <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | |

Work Order ID 113268

February-12-14 10:42:27 AM

113268

Page 2

Item ID: 646.9710

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Body

Start Date: 2/12/14 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 2/12/14 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | DAS 14 9-89 |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 5 | 0 | | |
| Quality Control | | | | | | | | | |
| 130 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | 5 | 0 | | |
| Quality Control | | | | | | | | | |
| 131 | | 0.00 | | | | | | | |
| *131* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | Clean & remove markings (acid etch only) | | | | | | | | |

14/04/03

DAS
44
9-89

14/04/04

14/04/03

N/A

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____ |
|--|--|---|---|

Work Order ID 113268

February-12-14 10:42:27 AM

113268

Page 3

| | | | |
|------------------------|-----------------|---------------------|--------------------------|
| Item ID: 646.9710 | Accept | *N900040100* | Setup Start *NS1* |
| Revision ID: | | | Stop *NS2* |
| Item Name: Body | | | |
| Start Date: 2/12/14 | Start Qty: 5.00 | *5* | Cust Item ID: |
| Required Date: 2/12/14 | Req'd Qty: 5.00 | *5* | Customer: |
| Reference: | | | |

| | | | | | |
|------------|---------------------|-------------|------------------|-------------|------------------------|
| Approvals: | Process Plan: _____ | Date: _____ | Tooling: _____ | Date: _____ | Run Start *NR1* |
| | QC: _____ | Date: _____ | SPC (Y/N): _____ | Date: _____ | Stop *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------------|
| 140 | Outsource process-Anodize per QSI017 4.1.10.1 | 0.00 | | | | | | | |
| *140* | | 0.00 | | | | | | | |
| Outsource4 | Memo | | | | | | | | |
| Outsource process - Anodize | Issue P/O to ATG : <u>23697</u> | | | | | | | | <u>C 214/04/08 (5)</u> |
| | 1- Black Anodize as per Dwg 646.9700 | | | | | | | | |
| | 2- PRIME AS PER DWG, SEE NOTE #2 | | | | | | | | |
| | Certification of Comformity is required | | | | | | | | |
| 150 | Receive & Inspect for Damage & Mat'l Certs | 0.00 | | | | | | | |
| *150* | | 0.00 | | | | | | | |
| Packaging | Memo | | | | | | | | <u>14/4/16 (5)</u> |
| Packaging | | | | | | | | | |
| 155 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *155* | | 0.00 | | | | | | | |
| QC | Memo | | | | | | | | <u>S</u> |
| Quality Control | | | | | | | | | |

DAS

27

3-89

14/4/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--|--|---|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Work Order ID 113268

February-12-14 10:42:27 AM

113268

Page 4

| | | | | | | |
|----------------|----------|------------|---------------------|-------|-------|--------------|
| Item ID: | 646.9710 | Accept | *N900040100* | Setup | Start | *NS1* |
| Revision ID: | | | | | Stop | *NS2* |
| Item Name: | Body | | | | | |
| Start Date: | 2/12/14 | Start Qty: | 5.00 | | | |
| | | | *5* | | | |
| Required Date: | 2/12/14 | Req'd Qty: | 5.00 | | | |
| | | | *5* | | | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|-------------------|------------------|----------------|
| 180 | Identify as per dwg & Stock Location: <u>CA</u> | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | 5x | DAS 28 9-88 | APR 16 2014 | |
| Packaging | ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** | | | | | | | | |
| 190 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14-4-17

14-04-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|---|
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|--|--|---|---|

Picklist Print

February-12-14 9:52:51 AM

Page 1

Work Order ID: 113268

Parent Item: 646.9710

Parent Item Name: Body

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M7075T6B5.000X1.000 | | Purchased | No | | | 100 | f | 218.3800 | 0.62 | 3.263158 | | | |
| 7075-T6 BAR 5.000" X 1.000" | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

MAT008

218.38

125554

2

M125997

1

M126981

36

→ M127481

179.38

3.3 OK 14/03/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | |
| <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | |

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 113268 |
| Description: Body | Part Number: | 646.9710 |
| Inspection Dwg: 646.9700 Rev: C | | Page 1 of 2 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| 0.13 x 45° | +/-0.010 x 0.5° | .125X45° | — | | Vern | HL-D6 |
| 1.500 | +/-0.005 | 1.500 | — | | " | |
| 0.352 | +0.005/-0.000 | .353 | — | | " | |
| 0.10 x 45° | +/-0.010 x 0.5° | .110X45° | — | | " | |
| 0.875 | +/-0.005 | .877 | — | | " | |
| 0.700 | +/-0.005 | .700 | — | | " | |
| 5.500 | +/-0.005 | 5.500 | — | | " | |
| 0.660 | +/-0.005 | .660 | — | | " | |
| 0.660 | +/-0.005 | .660 | — | | " | |
| 0.278 | +/-0.002 | .277 | — | | " | |
| 0.339 | +/-0.002 | .339 | — | | " | |
| 0.352 | +/-0.002 | .352 | — | | " | |
| 0.372 | +/-0.002 | .372 | — | | " | |
| 1.067 | +/-0.002 | 1.067 | — | | " | |
| 2.608 | +/-0.002 | 2.608 | — | | " | |
| 2.750 | +/-0.002 | 2.750 | — | | " | |
| 2.892 | +/-0.002 | 2.892 | — | | " | |
| 3.348 | +/-0.002 | 3.348 | — | | " | |
| 3.597 | +/-0.002 | 3.597 | — | | " | |
| 3.847 | +/-0.002 | 3.847 | — | | " | |
| 0.351 | +/-0.002 | .351 | — | | " | |
| 0.544 | +/-0.002 | .544 | — | | " | |
| 2.195 | +/-0.002 | 2.195 | — | | " | |
| 2.304 | +/-0.002 | 2.304 | — | | " | |
| 2.451 | +/-0.002 | 2.451 | — | | " | |
| 2.639 | +/-0.002 | 2.639 | — | | " | |
| 3.395 | +/-0.002 | 3.395 | — | | " | |
| 3.495 | +/-0.002 | 3.495 | — | | " | |
| 4.551 | +/-0.002 | 4.551 | — | | " | |
| 4.595 | +/-0.002 | 4.595 | — | | " | |
| 4.687 | +/-0.002 | 4.687 | — | | " | |
| 4.734 | +/-0.002 | 4.768 | — | | " | |
| 6.651 | +/-0.002 | 6.651 | — | | " | |

| | | | |
|---|--|---------------------|----------|
| DART AEROSPACE LTD | | Work Order: | 113268 |
| Description: Body | | Part Number: | 646.9710 |
| Inspection Dwg: 646.9700 Rev: C | | Page 2 of 2 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.201 | +0.005/-0.001 | Ø.201 | — | | Vern | M1-D6 |
| Ø0.177 | +0.005/-0.001 | Ø.177 | — | | | |
| 7.026 | +/-0.005 | 7.025 | — | | | |
| 4.245 | +/-0.005 | 4.244 | — | | | |

| | | | | | |
|---------------------|------------|--------------------|------------|------------------------------|--|
| Measured by: | 14 9-89 | Audited by: | 44 9-89 | Preliminary Approval: | |
| Date: | 14/03/03 | Date: | 14/04/04 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------|------------|----------|
| A | 13.06.03 | New Issue | KJ | |
| B | 13.07.18 | Dwg Rev updated | KJ | |
| C | 14.01.21 | Dwg Rev updated | KJ | |

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04039

SHEET 1 OF 1

DWG NO. 646.9700

REV: B

PREPARED
BY

D. PETERS

DATE: 08/09/13

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: MARKED INSPECTION DIMENSIONS

ECR:

NONE

113268 MLJ
1402-13

DOCUMENTS EFFECTED:

☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

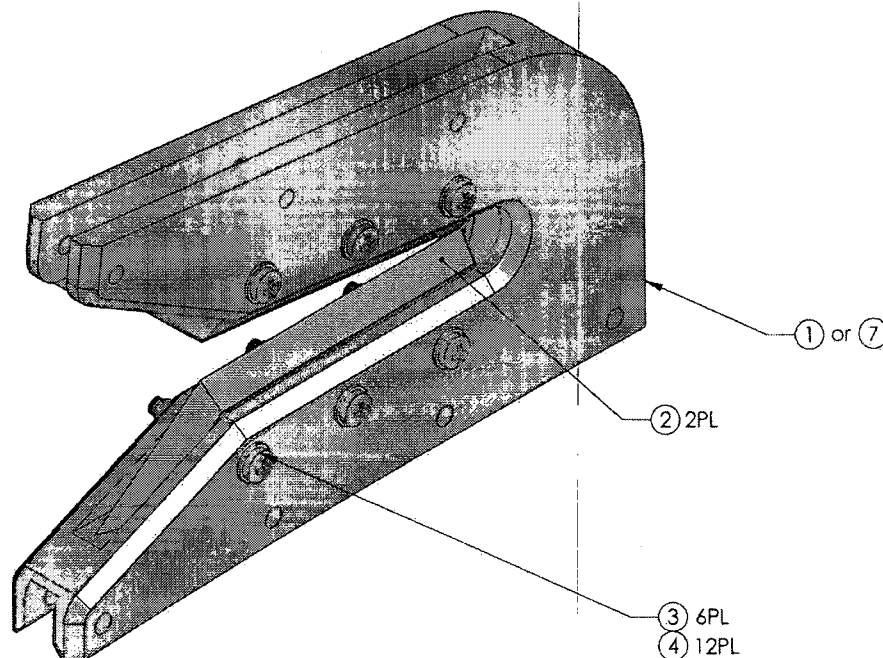
DER REVIEW REQUIRED
☐ YES ☒ NO

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| REVISIONS | | | |
|-----------|--------------------------------------|----------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |
| 1 | LAST PROTOTYPE REVISION: PRP | | NAC |
| NAC | INITIAL RELEASE | 05/29/09 | P. BRAYO |
| A | INCORPORATED ECH 02744, 03008, 03917 | 06/06/13 | P. BRAYO |
| B | INCORPORATED ECH 03917 | 07/20/13 | P. BRAYO |
| C | INCORPORATED ECH 04037 | 08/01/13 | P. BRAYO |

NOTES:

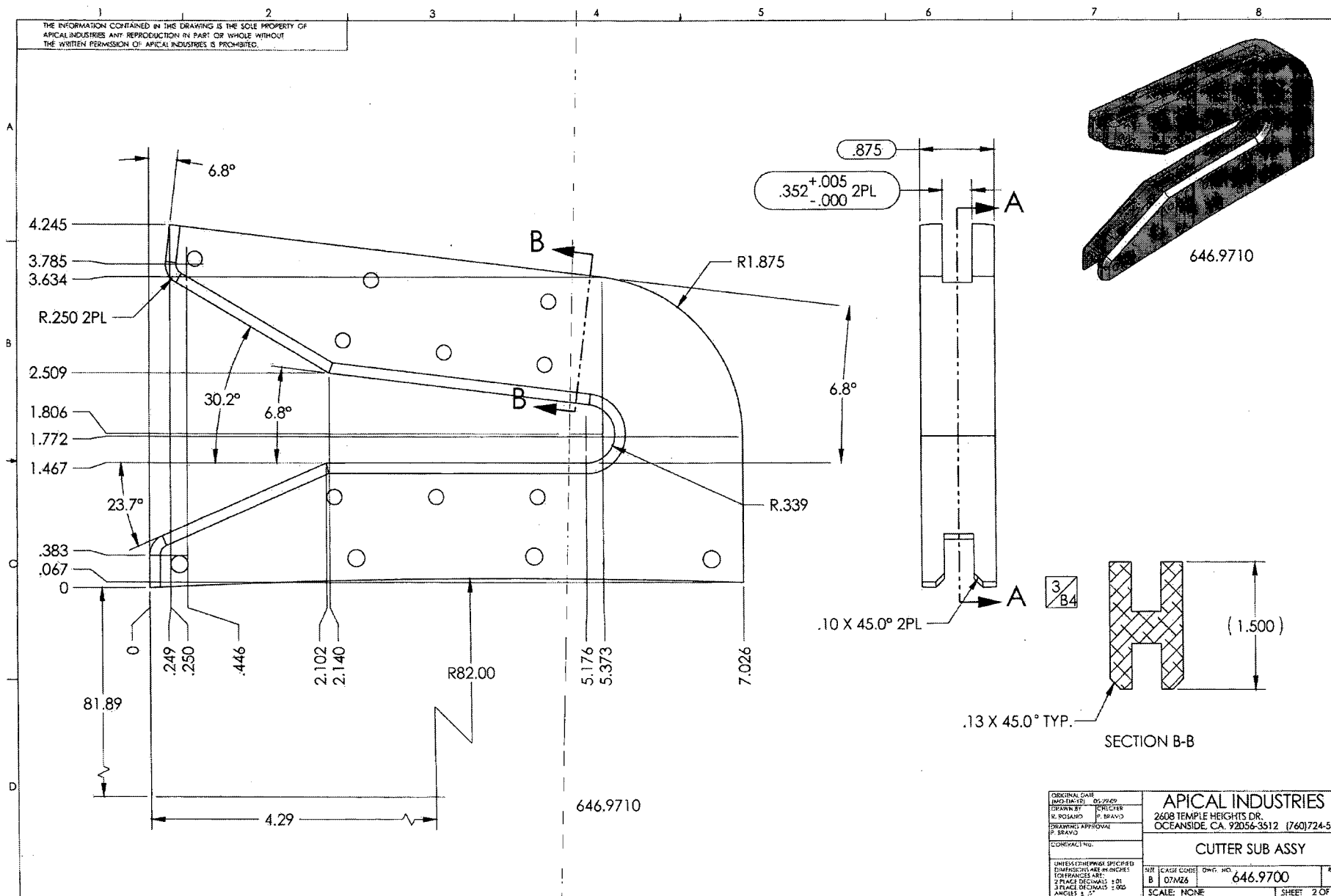
- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.



646.9701
or
646.9702

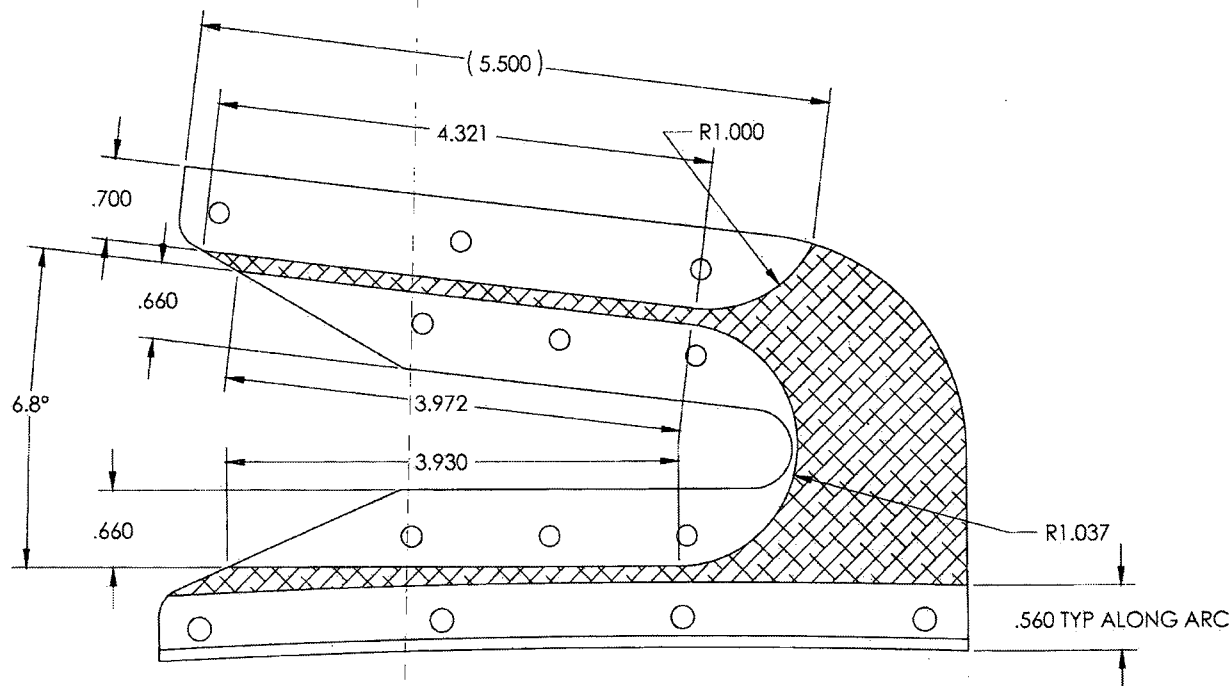
| | | | | | | |
|---------------|------|--------|----------|--|----------------------|-----------|
| 1 | | 7 | 646.9712 | BODY (U CHANNEL) | △ | △△ |
| 6 | 6 | 4 | 601.1541 | LOCKNUT | MS21042L08 | |
| A/R | A/R | 5 | 601.2764 | RTV, LOCTITE 598 | | |
| 12 | 12 | 4 | 601.2764 | WASHER | HA311475H8129 | |
| 6 | 6 | 3 | 601.2765 | SCREW | MS27039-0819 | |
| 2 | 2 | 2 | 646.9711 | BLADE | | △ |
| | 1 | 1 | 646.9710 | BODY | | △ |
| | | | 646.9702 | CUTTER SUB ASSY (U CHANNEL) | | |
| | | | 646.9701 | CUTTER SUB ASSY | | |
| 9702 | 9701 | FIND # | PART # | DESCRIPTION | MAT'L | SPEC. |
| QTY | | | | PARTS LIST | | |
| NEXT ASSY (S) | | | | APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 | | |
| 646.9600 | | | | | | |
| | | | | CUTTER SUB ASSY | | |
| | | | | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .3° | | |
| | | | | SHEET CODE B 07M26 | DWG. NO. 646.9700 | REV. C |
| | | | | SCALE NONE | SHEET 1 OF 6 | |

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| | | | |
|--|--|--|----------|
| ORIGINAL DATE 05/29/09 | | APICAL INDUSTRIES | |
| DRAWN BY W. ROSARIO | | 2608 TEMPLE HEIGHTS DR. | |
| CHECKED BY P. BRAVO | | OCEANSIDE, CA 92056-3512 (760)724-5300 | |
| DRAWING APPROVAL P. BRAVO | | CUTTER SUB ASSY | |
| CONTRACT NO. | | 646.9700 | |
| UNITED STATES SPECIFICATIONS DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5° | | SIZE B | REV C |
| SCALE: NONE | | SHEET 2 OF 6 | |

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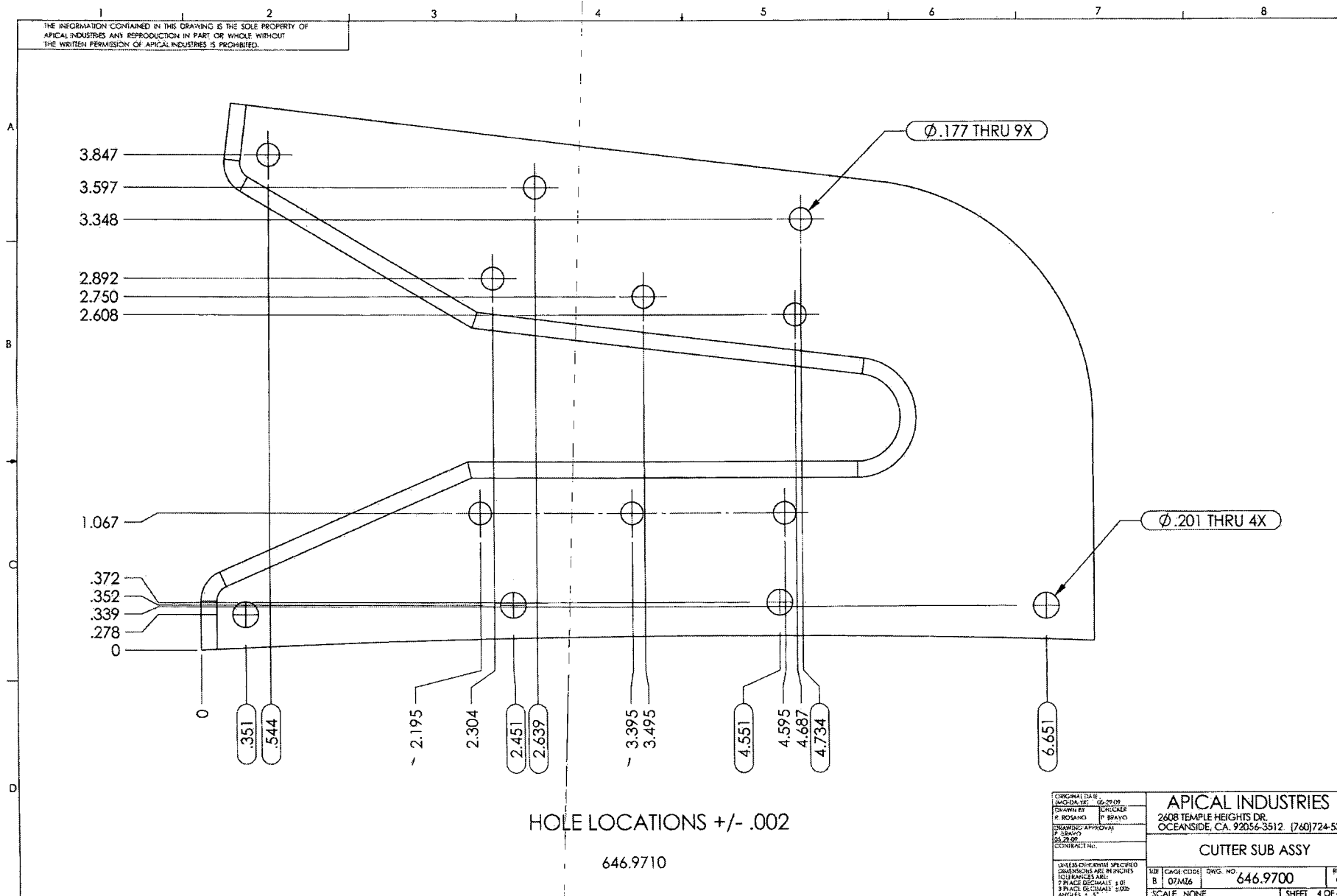


SECTION A-A $\frac{2}{C6}$

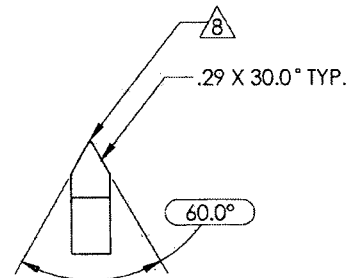
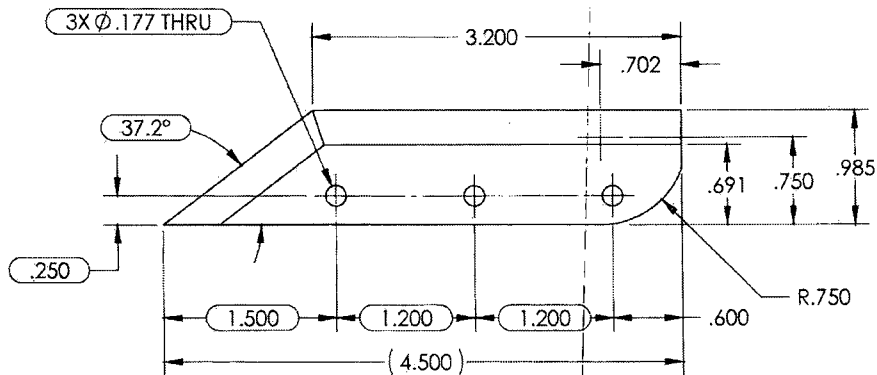
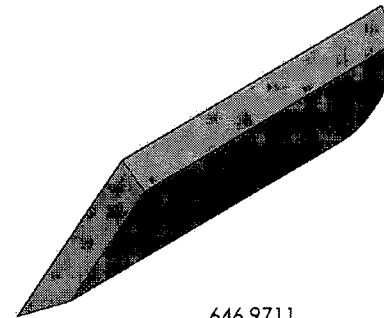
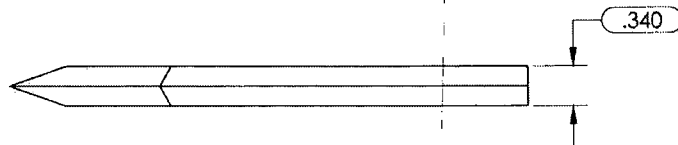
646.9710

| | | | |
|-------------------------------|--|---------------------------|--|
| ORIGINAL DATE: 03/21/09 | | APICAL INDUSTRIES | |
| DRAWN BY: J. B. BROWN | | 2608 TEMPLE HEIGHTS DR. | |
| P. ROMANO | | OCEANSIDE, CA. 92056-3512 | |
| DRAWING APPROVAL: J. B. BROWN | | (760) 724-5300 | |
| P. ROMANO | | CUTTER SUB ASSY | |
| CONTRACT NO. | | | |
| UNLESS OTHERWISE SPECIFIED | | SHEET: 3 OF 6 | |
| DIMENSIONS ARE IN INCHES | | SCALE: NONE | |
| TOLERANCES ARE: | | | |
| 3 PLACE DECIMALS ± .01 | | | |
| 2 PLACE DECIMALS ± .005 | | | |
| ANGLES ± .5° | | | |

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646.9711

ORIGINAL DATE
10-24-1981 05-29-83
DRAWN BY
P. KOSLAND P. BRAVO
DRAWING APPROVAL
P. BRAVO
DATE 07-26-83
CONTRACT NO.

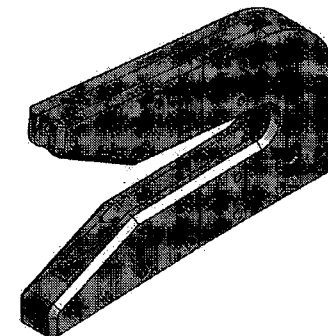
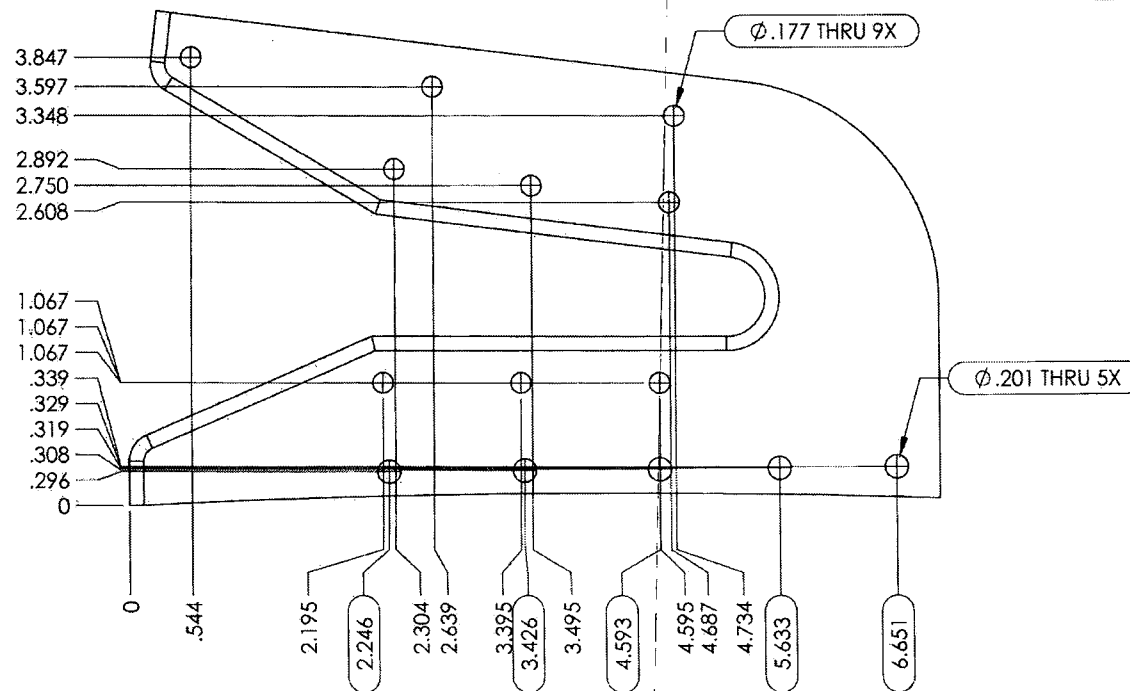
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE
2 PLACE DECIMALS ± .01
3 PLACE DECIMALS ± .005
ANGLES ± 5°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300

CUTTER SUB ASSY

| | | | | | | | |
|------------|---|-----------|-------|----------|----------|--------------|---|
| REV. | 8 | DATE CODE | 07M26 | DWG. NO. | 646.9700 | REV. | C |
| SCALE NONE | | | | | | SHEET 5 OF 6 | |

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646.9712 9

| | | | |
|---|--------------------|---|------------------|
| ORIGINAL DATE: 05-29-09 (MFG 04-18) | | APICAL INDUSTRIES | |
| DRAWN BY: J. HOSANO | ENGINEER: P. BRAVO | 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 | |
| DRAWING APPROVAL: P. BRAVO 05-29-09 | CONTRACT NO. | CUTTER SUB ASSY | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$ | | REV. B | C |
| SCALE: NONE | | DATE: 07/16/16 | QWL NO: 646.9700 |
| | | SHEET 6 OF 6 | |



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO23697**

Purchase Order Date 4/8/2014

PO Print Date 4/16/2014

Page Number 1 of 2

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone

613-446-4544

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

| Line Nbr | Reference Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | CD | Req Qty/ Unit of Measure | PO Unit Price | Extended Price |
|-------------------|------------------------------|---------------------|-------------------|----|--------------------------|---------------|----------------|
| Line Comments | | | Promise Date | | | | |
| Delivery Comments | | | | | | | |

| | | | | | | | |
|---|--------|--------------------------|-----------|--|------|---------|---------|
| 1 | 115082 | 647.1611 WIPER DEFLECTOR | 4/23/2014 | | 5.00 | \$10.70 | \$53.50 |
|---|--------|--------------------------|-----------|--|------|---------|---------|

Yes

4/23/2014

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$53.50

| | | | | | | | |
|---|--------|---------------|-----------|--|------|---------|---------|
| 2 | 113268 | 646.9710 BODY | 4/23/2014 | | 5.00 | \$14.50 | \$72.50 |
|---|--------|---------------|-----------|--|------|---------|---------|

Yes

4/23/2014

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$72.50

| | | | | | | | |
|---|--------|---------------|-----------|--|------|--------|---------|
| 3 | 116148 | 647.0410 TUBE | 4/23/2014 | | 5.00 | \$8.65 | \$43.25 |
|---|--------|---------------|-----------|--|------|--------|---------|

Yes

4/23/2014

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Note:

4/16/2014



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62987

Date: 16-Apr-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

| Terms | | Ship Via | |
|--|--|-----------|-------|
| Quantity | Description | Rev: | |
| 1 | Part: ASST | | |
| lot | 5 PCS 647.1611 (10.70) 5 PCS 646.9710 (14.50) 5 PCS 647.0410 (8.65) HARS ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PRICE IS PER PIECE Job: 20140220 | PO: 23697 | Line: |
| <p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE : <u>16/4/14</u></p> <p>CERTIFIED SIGNATURE : <u></u></p> <p>RECEIVER SIGNATURE : _____</p> | | | |

